

Work Order ID 61789

Friday, September 03, 2010 10:13:26 AM



Page 1

Item ID: D3784-041

Accept



Setup Start



Revision ID:

Item Name: Seat Support Assembly, Center

Stop



Start Date: 9/3/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *K*

Date: 10-9-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3784	Rev B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1-assemble as per dwg D3784								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

SB 11/01/21

③

SB 11/01/21

③

S 11/01/21

③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: 249

0.00



Packaging

Memo

0.00

Packaging

all parts

(30)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

OK 11/01/24
CMF
12-01-21

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, September 03, 2010 10:13:30 AM

Page 1

Work Order ID: 61789

Parent Item: D3784-041

Parent Item Name: Seat Support Assembly, Center

Start Date: 9/3/2010

Required Date: 9/13/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-05-19 new issue DD verified by:ec
IPP Rev:B 08-07-18 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN525-10R20

Purchased

No

110

Each

106.0000

2

8



Screw



SB 11/01/21

Location

Loc Qty

Loc Code

ST325

106

113524

0

114227

6

114348

50

114354

50

3
3

AN960JD10L

NAS1149D0332J

Purchased

No

110

Each

2,471.000

2

8



Washer



SB 11/01/21

Location

Loc Qty

Loc Code

ST348

2471

110985

2471

M 116 441

C

D3763-041

Manufactured

No

110

Each

7.0000

1

4



End Fitting Assembly



SB 11/01/21

Location

Loc Qty

Loc Code

ST251

3

55380

1

60456

2

ST251A

4

57929

4

B 61831

SB

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Friday, September 03, 2010 10:13:30 AM

Page 2

Work Order ID: 61789

Parent Item: D3784-041



Parent Item Name: Seat Support Assembly, Center



Start Date: 9/3/2010



Required Date: 9/13/2010

Start Qty: 4.00

Required Qty: 4.00

D3763-045	Manufactured	No	110	Each	2.0000	1	4
							SB 11/01/21
End Fitting Assembly							

			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	
D3770-1	Manufactured	No	ST251A	B62477 2	110	Each	9.0000
			54315	B62017 2			1
Tube							4
							SB 11/01/21

			<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>	
MS21042L3	Purchased	No	ST248A	9	110	Each	2,109.000
			56569	9			2
Nut							8
							SB 11/01/21

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	2109	
114523	109	
114784	2000	
115835		6

Friday, September 03, 2010 10:13:30 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

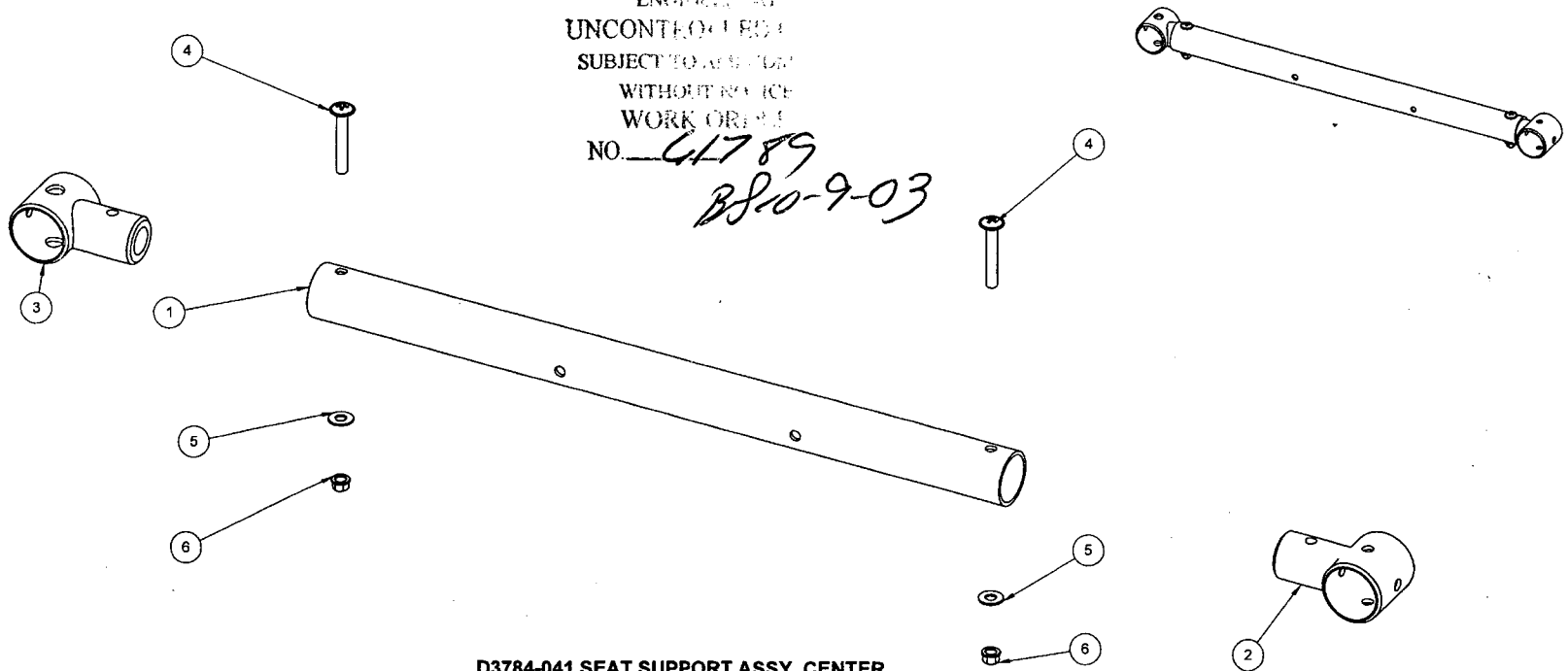
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOW COPY
 ENGINEERING
 UNCONTROLLED
 SUBJECT TO CHANGE
 WITHOUT NOTICE
 WORK ORDER
 NO. *41789*
BS-0-9-03



D3784-041 SEAT SUPPORT ASSY, CENTER

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-041)
1	D3770-1	TUBE	1
2	D3763-041	END FITTING ASSY	1
3	D3763-045	END FITTING ASSY	1
4	AN525-10R20	SCREW	2
5	NAS1149D0332J	WASHER (AN960JD10L)	2
6	MS21042L3	NUT	2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

B	HARDWARE CHANGE, ASSY CHANGE	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS	DRAWING NO.	REV. B
CHECKED	HS	D3784	SHEET 1 OF 5
MFG. APPR.	HS	TITLE	SCALE
APPROVED	HS	SEAT SUPPORT ASSEMBLY	NTS
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DATE	08.06.23		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

A

D

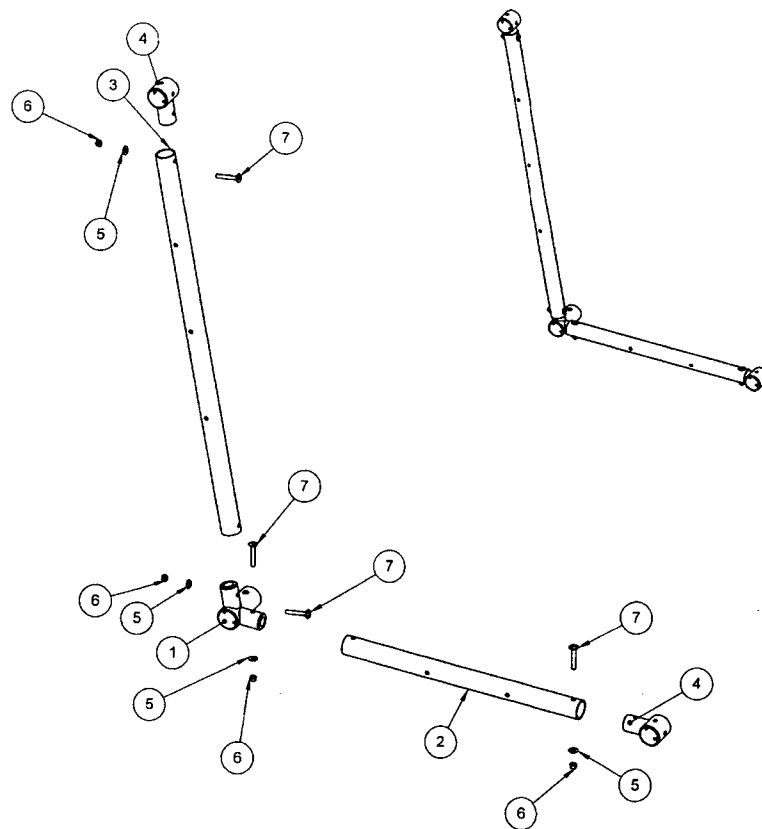
C

B

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-043)
1	D3763-043	END FITTING ASSY, LH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	NAS1149D0332J	WASHER (AN960JD10L)	4
6	MS21042L3	NUT	4
7	AN525-10R20	SCREW	4

△
B
△
B
△
B



D3784-043 SEAT SUPPORT ASSY, LH

w/o 40789

RELEASED
08.07.10

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.78 lbs

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MFG. APPR.	ND	D3784	SHEET 2 OF 5
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DE APPR.	ND	SEAT SUPPORT ASSEMBLY	NTS
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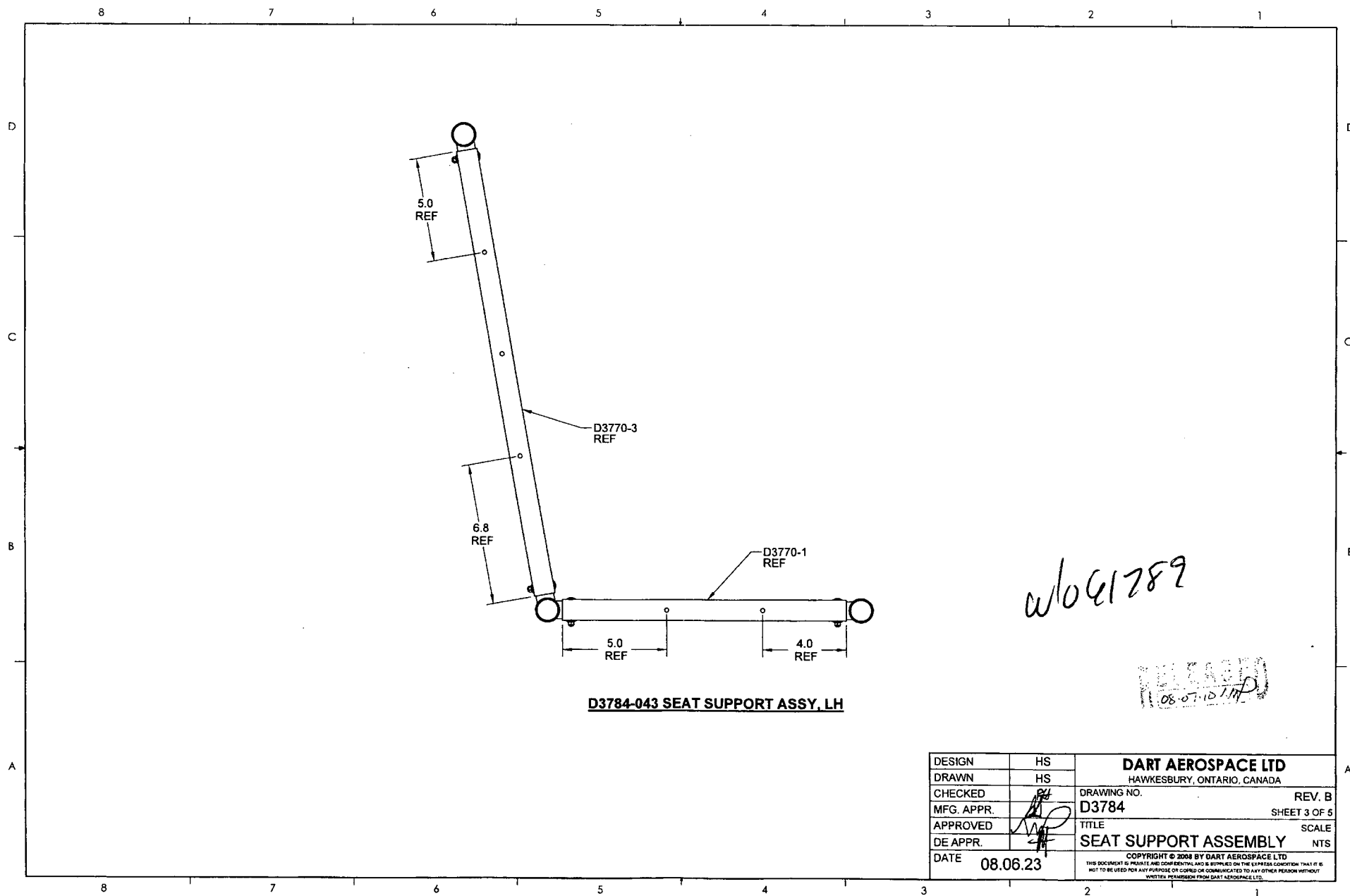
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

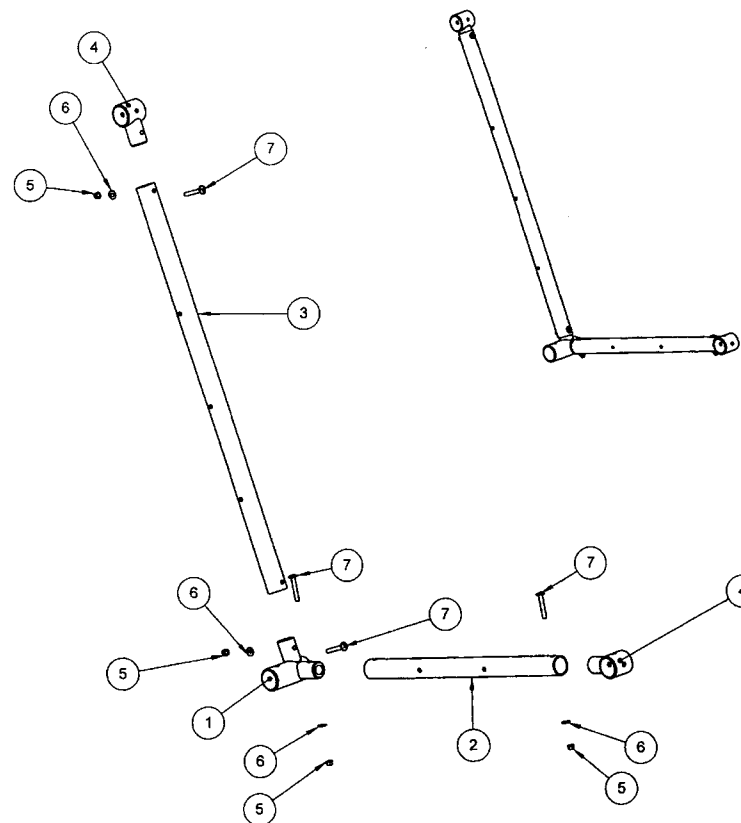
C

B

A

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. (-044)
1	D3763-044	END FITTING ASSY, RH	1
2	D3770-1	TUBE	1
3	D3770-3	TUBE	1
4	D3763-041	END FITTING ASSY	2
5	MS21042L3	NUT	4
6	NAS1149D0332J	WASHER (AN960JD10L)	4
7	AN525-10R20	SCREW	4

△
B
△
B
△
B



D3784-044 SEAT SUPPORT ASSY, RH

W/ 41789

RELEASED
08-07-2010

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.78 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3784	SHEET 4 OF 5
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8 7 6 5 4 3 2 1

Dart Aerospace Ltd

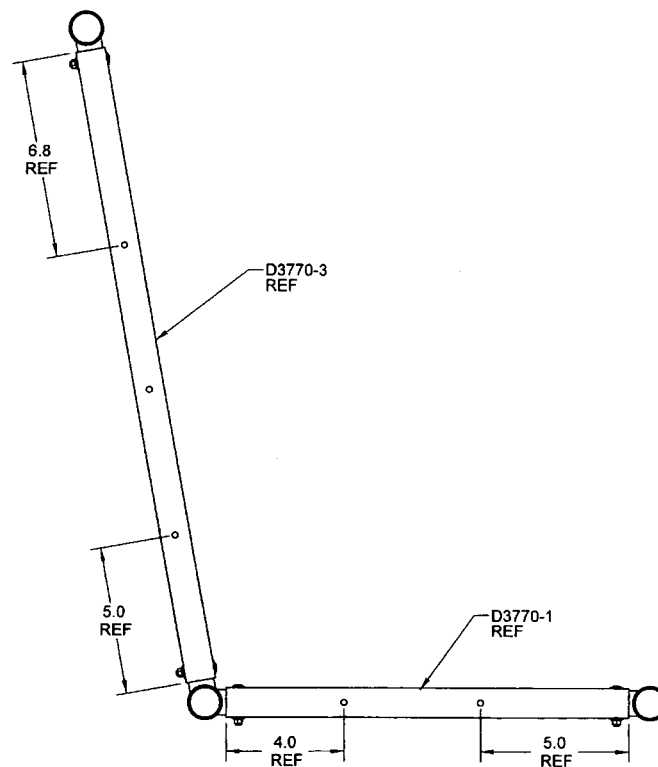
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D3784-044 SEAT SUPPORT ASSY, RH

w/b 41789

RELEASED
08.07.10

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